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D4436-045
Job Sheet 188064



Part No: D4436-045

Job Qty: 4 ea

Part Name: Aft Inboard Bracket Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/2/19

Job Tracking No:

Due Date: 1/11/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: D4436 REV.B IPP revA 11.10.06 new issue EC verified by:DD IPP RevB 11.12.22 per PA2 EC verified by:JLM
IPP REV:C 12.01.24 PER DWG REV.A DD VERF:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	4 pcs	1/11/19	1/11/19	0.00	0.71	Waterjet - Flow		OC 19/02/19
110	QC	4 pcs	1/11/19	1/11/19	0.00	0.00	QC2 Waterjet-3		OC 19/02/19
120	QC	4 pcs	1/11/19	1/11/19	0.00	0.00	QC8-4		FEB 20 2019
125	Small Fab	4 pcs	1/11/19	1/11/19	0.00	0.78	Small Fab-6		36 9-89
130	Brake NC	4 pcs	1/11/19	1/11/19	0.08	0.55	Brake NC 2		DAS 9-89
150	QC	4 pcs	1/11/19	1/11/19	0.00	0.00	QC5		58
160	HandFinish	4 pcs	1/11/19	1/11/19	0.00	0.34	HandFinish1		9-89 FEB 22 2019
170	QC	4 pcs	1/11/19	1/11/19	0.00	0.00	QC7-3		28 9-89
180	Small Fab	4 pcs	1/11/19	1/11/19	0.00	0.78	Small Fab-6		9-89
185	QC	4 pcs	1/11/19	1/11/19	0.00	0.00	QC5		36 9-89
190	Powdercoat	4 pcs	1/11/19	1/11/19	0.00	0.20	Powdercoat4		OC 19-2-22
200	QC	4 pcs	1/11/19	1/11/19	0.00	0.00	QC3		DAS
202	Small Fab	4 pcs	1/11/19	1/11/19	0.00	0.78	Small Fab-6		58 FEB 25 2019
205	QC	4 pcs	1/11/19	1/11/19	0.00	0.00	QC5		9-89
210	Packaging	4 pcs	1/11/19	1/11/19	0.00	0.00	Packaging3-2		21
220	QC21-SA	4 Ea	1/11/19	1/11/19	0.00	0.00	QC21		9-89 FEB 25 2019

Part Op 100 - 1-Cut D4436-3 as per Dwg Dwg Rev: B Prog Rev: B 2-Deburr if necessary

Descriptions: 125 - 1- Transfer drill holes as per dwg. 2-C"SINK AS PER DWG 3-TRANSFER 0.129 HOLES THRU (2 PLACES)

180 - Assemble as per dwg, do not install grommets and rubber seal.

190 - START TIME: 10:25 OVEN TEMPERATURE: 300 FINISH TIME: 10:55.

202 - Cut qty 1 to 3.8" Cut qty 1 to 10.00" Install rubber seals and grommets, as per dwg

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.040	6061-T6 .040 Sheet	2.7560 sf (.689 ea)	100-Waterjet - Flow - 1	S152150
MS20426AD3-2/3	Rivet	32 16 Ea (4 ea)	180-Small Fab	5018535
MS20470AD4-3	Rivet, Universal Head	16 8 Ea (2 ea)	180-Small Fab	5089460
MS21075L08	Anchor Nut	16 8 Ea (2 ea)	180-Small Fab	50128635-0
D4441-1	Rubber Seal	4.6000 ft (1.15 ea)	202-Small Fab	5092167
MS35489-19	Grommet	4 Ea (1 ea)	202-Small Fab	5067899

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____					

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M6061T6S.040	3	11	0
180-Small Fab	MS20426AD3-2	16	18,520	0
	MS20470AD4-3	8	4,753	0
	MS21075L08	8	59	0
202-Small Fab	D4441-1	5	483	0
	MS35489-19	4	78	0

Part Specifications

Specifications could not be found.

Plex 1/2/19 1:23 PM Dart.lajeunesse.marie

Entered: _____ Date: _____



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Route update only ☐

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Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



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Container No: S154672



Part: D4436-045

Job No: 188064

Serial No/Batch: S154672

Revision: B

Inspector:

Exp Date:

Instructions: Various STC's

Date: 02/15/19